

Work Order ID 150071***150071***

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Monday, October 03, 2016 1:30:44 PM

Item ID: D2761-108 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Extrusion (HPK)
Start Date: 8/26/2016 Start Qty: 1,053.00 ***1053*** Cust Item ID:
Required Date: 9/9/2016 Req'd Qty: 1,053.00 ***1053*** Customer:

Reference:

Approvals: Process Plan: **DAS 13 9-89** Date: **OCT 03 2016** Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2761	Rev A1								

100

0.00

100

Purchasing

PURCHASING

Memo

0.00

Purchasing

Issue P/O: **33497****CX 16/10/03 1053 ft**

ATTN: ORDER IN FEET- SUPPLIER WILL TAKE THIS AS PCS...

a) Extrude as per Dwg D2761

b) Material: 6061-T6 (QQ-A-200/8)

c) No tooling ID mark

d) Extrusion is symmetric about center line

e) Signature Aluminum Order at 108" long

g) Material certification required

***EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE
SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH
AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS,
OR DENTS.***

MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.00							
Packaging	Ensure material certification is attached								
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control	Ensure certification comply to Dwg D2761 Check hardness with Webster instrument								
130	Identify as per dwg & Stock Location: <u>Shed</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging	LOCATION: MAT051								

10/16/15 x Pull 24 20 pcs for inspection

1053 ft 8/16-10-3

117 12/10/05

1053 16-11-17

150071

Monday, October 03, 2016 1:30:44 PM

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Revision ID:						
Item Name:	Extrusion (HPK)				Stop	*NS2*
Start Date:	8/26/2016	Start Qty: 1,053.00	*1053*	Cust Item ID:		
Required Date:	9/9/2016	Req'd Qty: 1,053.00	*1053*	Customer:		
Reference:						

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

[illegible]

15-16-11-12

Picklist Print

Monday, October 03, 2016 1:30:43 PM

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Work Order ID: 150071

150071

Parent Item: D2761-108

D2761-108

Parent Item Name: Extrusion (HPK)

Start Date: 8/26/2016

Required Date: 9/9/2016

Start Qty: 1,053.00

Required Qty: 1,053.00

Comments: B01.05.03Re formatEC

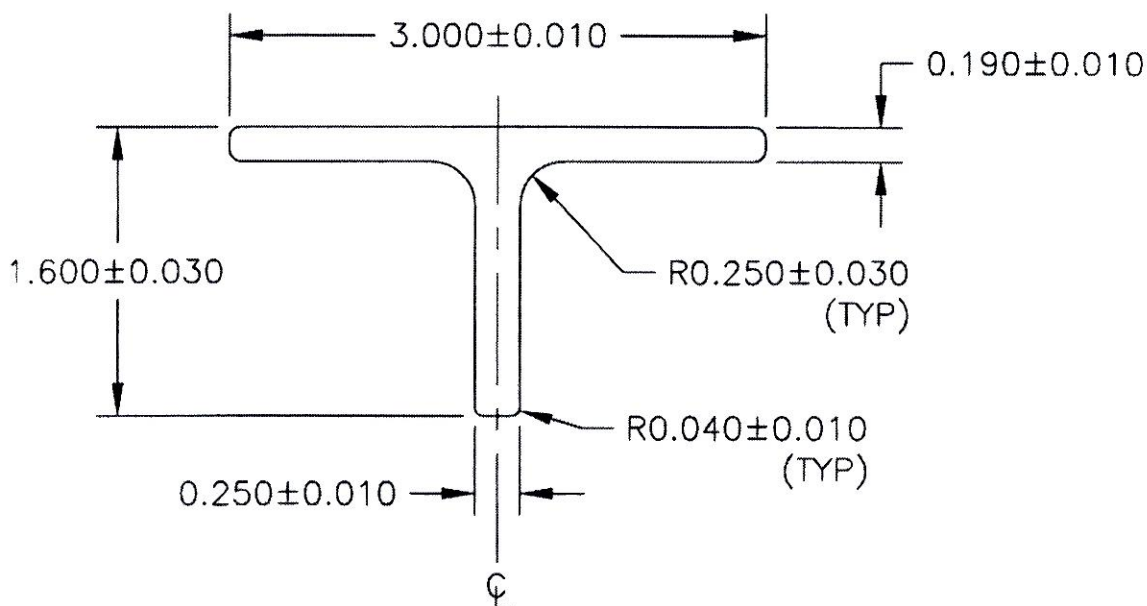
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2761-108P		Purchased	No			100	f	0.0000	1	1053			
D2761-108P									**				
Extrusion													

1053 PK 8/16-10-3.



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MEY</i>	APPROVED <i>KE</i>	DRAWING NO. D2761	REV. A SHEET 1 OF 1
DATE 98.03.16		TITLE EXTRUSION	SCALE 1:1
A	98.03.16	NEW ISSUE	
A1	01.04.17	ADD NOTES 4 & 5 <i># CP</i>	

RELEASED
98101/03 KE



1. MATERIAL: 6061-T6 (QQ-A-200/8).
2. NO TOOLING ID MARK.
3. EXTRUSION IS SYMMETRIC ABOUT CL.
4. MANUFACTURED USING CARADON INDALEX DIE # MS-19021
5. PART NUMBER IS D2761-XXX WHERE XXX IS CUT LENGTH IN INCHES
EG. D2761-108 IS 108" LONG

1500714.5
1608-23
CONTROLLED COPY
ENGINEERING
RETURN TO
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO33497

Purchase Order Date 8/31/2016 11:03:04 AM

PO Print Date 9/30/2016

Page Number 2 of 3

Order From : VC-BON001

SIGNATURE ALUMINUM CANADA INC.
C/O/ T10322C
P.O. BOX 4488, STN A
TORONTO, ON M5W 4H1
CA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 905-427-6550

Ship To Contact
Ship To Phone
Ship Via: Yours ppd
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Line Total: \$3,443.75

3 D2761-108P Extrusion ✓ 9/30/2016 468.00 \$7.21 \$3,375.18
Yes
9/30/2016

EXTRUDE AS PER DWG D2761 REV. A
B150071
DIE # MS-19021

EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF TUBE
MATERIAL MUST BE SMOOTH AND FREE FROM DEFECT SCRATCHES,NICKS,DENTS

5016-10-3

Line Total: \$3,375.18

4 71401-45 PROCUREMENT 9/30/2016 1.00 \$0.00 \$0.00
QUALITY CLAUSES

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)
A026 certification of material conformance
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

No
9/30/2016

Note:

9/30/2016



ACCT# 46024

1850 Clements Road, Pickering Ontario, Canada L1W 3R8 INVOICING AND COMPANY LOCATION

Phone: (866) 587-5780 Fax: (905) 427-2207

Visit us at www.signaturealuminum.comSIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

PACKING LIST

PACKING LIST DATE / DATE DU
09-29-16PACKING LIST NUMBER / N° DE
028337SALES ORDER NUMBER / N° DE COM
124894

SHIP TO / EXPÉDIÉ À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

SOLD TO / VENDUE À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

TERMS / FREIGHT

PP

REFER TO
THESE NUMBERS ON
ALL CORRESPONDANCEREFEREZ-VOUS A CES
NUMEROUS POUR TOUTE
CORRESPONDANCE

CUSTOMER ID / ID DU CLIENT 46024		ORDER DATE / DE LA COM 08/31/16		CUSTOMER PO NUMBER / CLIENT PO Nombre PO33497			JOB / FICHIER		FIELD SALES REP / REP REGIONAL DES VENTES G.ATTENBOROU		CUST SERVICE REP / REP. SERVICE CLIENTELE M2A		
BILL OF LADING NUMBER / NO. DE CONNAISSEMENT 028337				CARRIER / TRANSPORTEUR MCGILLION									
ITEM NO. / NUMÉRO	ORIGINAL ORDER QUANTITY / Quantité d'ordre ORIGINAL	UNIT / UNITÉ	PREVIOUS SHIPPED QUANTITY / PRÉCÉDENT Quantité livrée	MFG. PART NUMBER / MFG. PARTIE NUMÉRO CUSTOMER PART NUMBER / NUMÉRO DE RÉFÉRENCE DU CLIENT	ALLOY & TEMPER / ALLIAGE & TEMPER LENGTH / LONGUEUR CUTTING TOLERANCE / Tolérance de coupe	FINISH DESCRIPTION / DESCRIPTION DE FINITION ABRICATION DESCRIPTION / DESCRIPTION DE FABRICATIO SHIPPING TOLERANCE / EXPÉDITION TOLERANCE	NBR OF PKGS / NBR DE PKGS	GROSS LBS / LIVRES BRUT	NET QUANTITY / QUANTITÉ NETTE	UNIT / UNITÉ	QUANTITY DUE / Quantité en raison		
003	1,104	LB		DAA-7-1	6061 T6		2	1,179	1,144	LB			
	501	KG		D2761-108P	108.0000 IN			535	519	KG			
	108	PC			Cut(+): 0.1180 Cut(-): 0.0000	Min: -10 % Max: 10 %			117	PC			
						871038 / 333572	1	655	637		65	PC	
						871038 / 333573	1	525	507		52	PC	

Sp/16-10-3

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping packing lists and signed and dated below by customers authorized representatives.
No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping packing list were produced in accordance with the specifications and standards of 1992 as amended. Orders accepted subject to the terms and conditions stated on the company side.

CUSTOMER ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION

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8	3,818	3,620	LB
	1,732	1,642	KG
		321	PC
TOTALS			

DATE OF DELIVERY

DRIVER

**SIGNATURE ALUMINUM CANADA**1850 CLEMENTS RD
PICKERING, ON L1W 3R8**CERTIFICATE OF COMPLIANCE**

Cert Date	Cert No.	Sales Order	Page
09/27/2016	5401003	124894	1
Cust PO	B/L No	Lot	Date
PO33497	028337	871038	09/29/16

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA

Item No	Part No	Item Description	Cust Part
003	DAA-7-1	9FT MILL 6061 T6	D2761-108P
Gross Weight	1,179 LBS		
Net Qty	1,144 LBS	117 PCS	2 PKGS
Specification	AMS-QQ-A-200/8 & ASTM B221-08		
	16/10/05 88-8 87 DAS SVD		

Mechanical Tests:

<u>Tensile</u>	<u>Yield</u>			
<u>MPA / KSI</u>	<u>MPA / KSI</u>	<u>% Elongation</u>	<u>Conductivity</u>	<u>HRE</u>
314.5 / 45.6	283.5 / 41.1	13.0	N/A	94

Chemical Analysis:

<u>Si</u>	<u>Fe</u>	<u>Cu</u>	<u>Mn</u>	<u>Mg</u>	<u>Cr</u>	<u>Zn</u>	<u>Ti</u>	<u>V</u>	<u>Zr</u>
0.70	0.27	0.20	0.03	0.91	0.07	0.03	0.01	0.01	0.00

*This Material is Made in Canada**This Material is RoHS Compliant*

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Mazzotta
Director of Quality
Signature Aluminum Canada Inc

ISO 9001/TS16949 Registered Company

Visit us at www.signaturealum.com

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D2761-108

PO / BATCH NO.: PO 33497 / 150071

DATE: 2016/10/05

MATERIAL CERT REC'D: yes

THICKNESS ORDERED: See inspection sheet

QUANTITY RECEIVED: _____

THICKNESS RECEIVED: "

QUANTITY INSPECTED: _____

SHEET SIZE ORDERED: N/A

QUANTITY REJECTED: _____

SHEET SIZE RECEIVED: N/A

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	Y	N	
CORRECT FINISH	☒	N	
CORROSION	Y	☒	
CORRECT GRAIN DIRECTION	☒	N	
CORRECT MATERIAL	☒	N	AMS-QQ-A-200/8
CORRECT THICKNESS	☒	N	See inspection sheet
PHOTO REQUIRED	Y	☒	
CORRECT MATERIAL	☒	N	6061 T6
CORRECT REF # TO LINK CERT	☒	N	PO 33497
CORRECT MATERIAL IDENTIFICATION	Y	N	
CORRECT M# ON THE MATERIAL	Y	N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	☒	
DOES THIS REQUIRE AN EXTRUSION REPORT	☒	N	See Attached Inspection Report

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
TYPE OF MATERIAL SIZE OF TEST SAMPLE HARDNESS / DUROMETER READING	HRC	HRB	DUR A	DUR D	<u>N/A</u>

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u>DAS</u>	SIGNED OFF BY: _____		
DATE: <u>9-89</u>	DATE: _____		
<u>10/01/05</u>			

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

MATERIAL RECEIPT INSPECTION FORM

INSTRUCTIONS FOR INSPECTING BAR, TUBING, ROUND, & SHEET STOCK

- 1- VERIFY STOCK TO DART PURCHASE ORDER
- 2- MEASURE ALL DIMENSIONS FOR EACH PURCHASED STOCK
 - a. WIDTH, THICKNESS, DIAMETER, WALL THICKNESS & LENGTH
- 3- VERIFY CONDITION OF MATERIAL i.e. DAMAGED, CORRODED, etc.
- 4- VERIFY THAT SUPPLIER HAS A NUMBER (HEAT #) ON ITS RECEIVING REPORT TO LINK TO MATERIAL CERTS
- 5- VERIFY MATERIAL CERTS ARE CORECT TO THE DART PO INSTRUCTIONS
- 6- REMOVE / CUT A PIECE OF MATERIAL FOR SAMPLE HARDNESS TESTING

INSTRUCTIONS FOR INSPECTING SKIDTUBE & STEP EXTRUSION

- 1- VERIFY TO DART SUPPLIED DRAWING
- 2- SAMPLE INSPECT MATERIAL IN BUNDLE TO ENSURE MATERIAL CAN BE RECEIVED INTO DART
- 3- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING
- 4- VERIFY THAT MATERIAL CERTS MATCH TO WHATS CALLED UP ON THE DART DRAWING

AFTER MATERIAL PASSES INSPECTION

- 5- HAVE DART EMPLOYEES START STOCKING MATERIAL BUT REQUEST MIN **20pcs** FOR FULL INSPECTION
- 6- INSPECT ALL DIMS AS PER DRAWING REQUIRMENTS

INSTRUCTIONS FOR INSPECTING CROSS TUBE MATERIAL

- 1- VERIFY MATERIAL CERTS MATCH THE REQUIRMENTS ON THE DART DRAWINGS
- 2- INSPECT MIN. HALF THE BATCH OF EXTRUSION RECEIVED INTO DART
- 3- INSPECT MATERIAL AS PER THE EXTRUSION REPORT
 - a. WALL THICKNESS USING ULTRA-SONIC IN 4 LOCATIONS
 - b. OUTSIDE DIAMETETER HIGHEST/LOWEST BOTH ENDS
 - c. INSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - d. STRAIGHTNESS @ CENTER OVER 12" SPAN
 - e. WALL THICKNESS USING TUBE MICROMETER HIGHEST/LOWEST BOTH ENDS
- 4- IDENTFY EACH TUBE IN SEQUENCE OF INSPECTING (TUBE 1, TUBE2.....) AND W/O# AND PO#
- 5- RECORD ALL FINDINGS ON EXTRUSION REPORT

IF ANY QUESTIONS PLEASE SEE QC CORR DINATOR BEFORE GOING FURTHER

